



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2600-3-BENT-LH
Job Sheet 167935



Part No: D2600-3-BENT-LH

Job Qty: 5 ea

Part Name: Extrusion Bent LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 11/17/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/16/17	11/16/17	0.00	0.00	Start up container		
100	CNC Bend Skid tubes	5 pcs	11/17/17	11/17/17	0.20	1.61	CNC Bend Skid tube		
110	QC	5 pcs	11/17/17	11/17/17	0.00	0.00	QC5		
120	Packaging	5 pcs	11/17/17	11/17/17	0.00	0.00	Packaging3		
130	QC21-SA	5 Ea	11/17/17	11/17/17	0.00	0.00	QC21		

Part Op 100 - Pick qty 1 D2600-3-130 extrusion 1-Deburr one end of extrusion 2-Bend using CNC bending machine as per Descriptions: program 2750.C and Folio 14 use bending aid DT9635 3- cut fwd end of tube as per dwg D2750 4- cut aft end of tube as per dwg D2750
120 - LOCATION : LG002

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation <i>F162497</i>	D2600-3-130	<i>X 9</i>	88	0	0

Part Specifications

Specifications could not be found.

Plex 11/8/17 11:13 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☒	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☒	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : 18/1/11

Step #: 100

QTY Effective :

MRB (QSI042) Approval

 DAS
12
9-89

18/1/11

Description Work Order Deviation

Disposition

Fwd skidtube bend is ~~25.5~~ 26.9° (dwg 28°).

Acceptable.

 Layout shows that D350-591 step
 slots are sufficient to accommodate angle
 of skidtube.

Completed By

 DAS
12
9-89

18/1/11

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval
DART
AEROSPACE
S031538

Dart Aerospace Ltd.

 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com


Extrusion Bent LH

PART NO: D2600-3-BENT-LH
Revision:
Operation: Start up Operation
Change No:

 Mfg Date: 01/11/18
 Job No: 167935

FAULT CATEGORY

ect te/Unqualified	☐	Power Loss/Surge	☐	Positioned Wrong
	☐	Folio/Program	☐	Outside Dimensions
	☐	Grain	☐	Over/Under tolerance
	☐	Weld	☐	Part Incorrect
	☐	Wrong Stock Pulled	☐	Part Lost/Missing
ete/Unclear	☐	Out of Sequence	☐	Part Moved
	☐	Off-set	☐	Drawing
	☐	Mislabeled	☐	Finish
	☐	Fit/Function	☐	Misread
	☐	Misaligned/off center	☐	Turning Sequence

SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

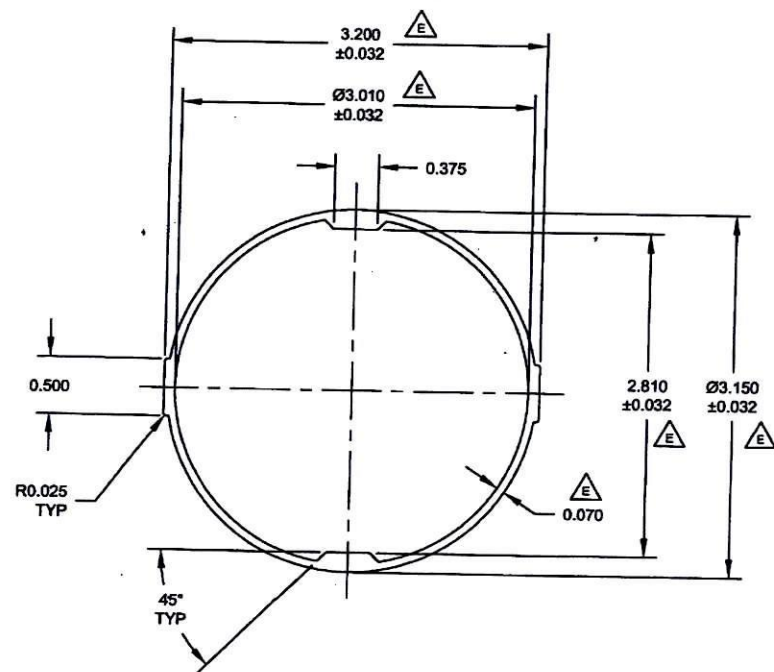
MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

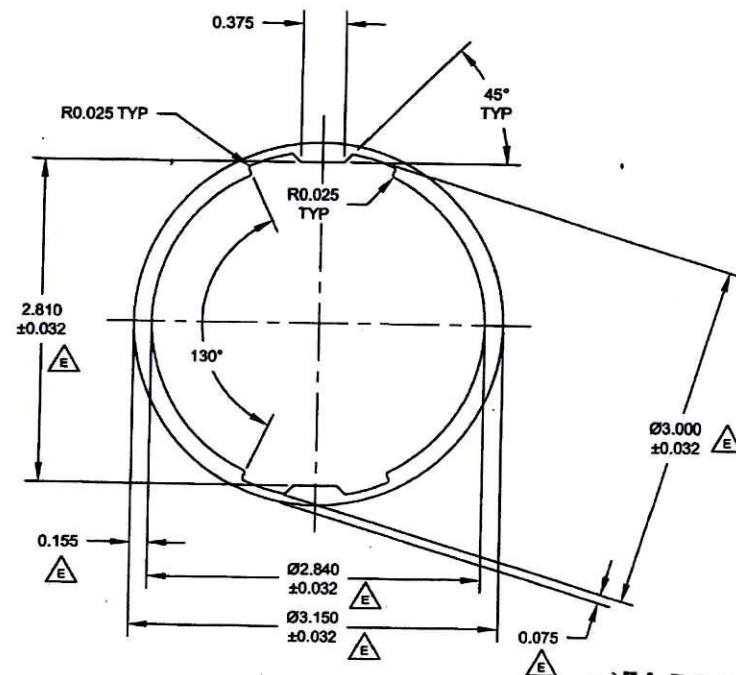
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
D2600-1 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18870
- SIGNATURE ALUMINUM (BON-L) DIE # 897121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
D2600-3 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18859
- SIGNATURE ALUMINUM (BON-L) DIE # 897122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
D2600-5 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
D2600-7 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18872

RELEASED
2012-01-11

E	REFORMAT DWG; ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3. UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN			
CHECKED	DRAWING NO.	REV. E	
MFG. APPR.	D2600	SHEET 1 OF 3	
APPROVED	TITLE	SCALE	
DE APPR.	EXTRUSION	NTS	
DATE	11.10.18	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2600-1 EXTRUSION



D2600-3 EXTRUSION

RELEASED
2012-01-10

DESIGN	4	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	E	D2600	SHEET 2 OF 3
APPROVED	WMP	TITLE	SCALE
DE APPR.		EXTRUSION	NTS
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Material Requisitions

R/S#: _____

Part Number: M Delrin R 1.500" Batch #: 134549 Quantity: .292'

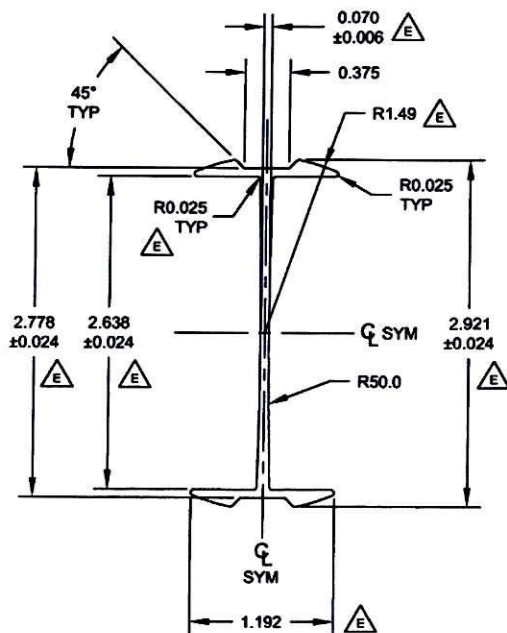
Received/taken by: S. J Date: 17-12-14

USED FOR: (must be completed)

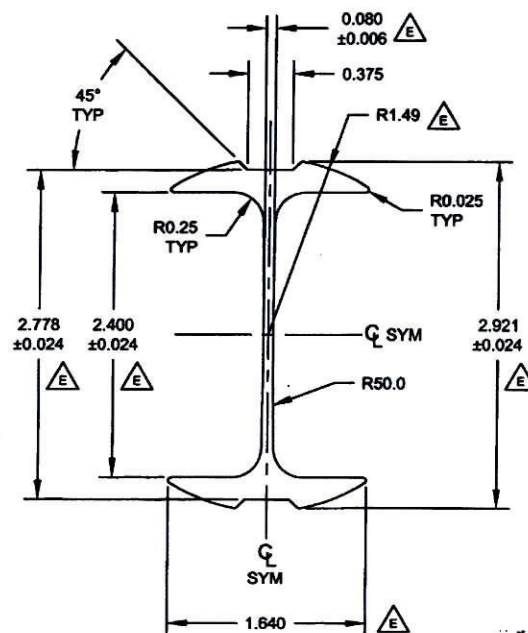
Engineering Project # P —

OR

Shop Tooling (non-work order) Jig for engraving on RBT103311-101



D2600-5 EXTRUSION



D2600-7 EXTRUSION

RELEASED
68 2012-01-11
JND

DESIGN	<i>4</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>4</i>		
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>4</i>	D2600	SHEET 3 OF 3
APPROVED	<i>4</i>	TITLE	SCALE
DE APPR.	<i>4</i>	EXTRUSION	NTS
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